120 QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Work Orde		716 0:39 PM				/110-11		<u> </u>	A		Page 1
Item ID: Revision ID:	D3243-041			Accept					Setup Sta	art	
Item Name:	Bracket Asser	nbly							St	top	
Required Date:	7/7/2011 7/21/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item I	D:					······································
Reference:							-		Run Sta	art	
Approvals:	Process Pla		Date: 11/07/0	7 Tooling:	D	ate:				9 t aa iii a i	
	QC:		Date:	_ SPC (Y/N):	D	ate:			51	top	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	√ Rev	vision Nbr							······································		
D3243	Rev	' A									
110	ار	HAAS CNC VERTICA	L MACHINING #1	0.00				ភាព	1-0-2		
Waterjet		Memo		0.00				(0,	1-8-3	- /	
FLOW CNC Waterje		1-Cut as po Dwg Rev: Prog Rev:	er Dwg							6	
		2-Deburr i	fnecessary								

0.00

0.00

1311-8-3

	. Johnson													
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Categ	ory:	NCF	R: Yes N	lo DQ	/:	Date: _					
	R	esolution:	Disposition	:	QA:	N/C Clo	sed:		Date: _					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC Section A	Initial	Corrective Action Security Action Description	Section B Sign &			ation	Approval Chief Eng	Approval QC Inspector				
		Section A	Chief Eng	Chief Eng		Date	Section		Criter Eng	QC Inspector				
								· · · · · · · · · · · · · · · · · · ·						
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V	ork/	Order	ID	71716
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Thursday, July 07, 2011 1:00:39 PM



Page 2

Item ID:

D3243-041

Accept

Setup Start



Revision ID:

Bracket Assembly Item Name:

Required Date: 7/21/2011

Start Date:

7/7/2011

QC:

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

130

Operation Description

NC BRAKE

QC8- Inspect parts - second check

Memo

Memo

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Quality Control

150

Brake NC

Brake NC

0.00

0.00

SB 11/08/24

160

QC5- Inspect part completeness to step on W/O

Form as per Dwg D3243

0.00

Duloelzy

Quality Control

Memo

0.00

W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								-					
Part No	:	PAR #:	Fault Category: N				NCR: Yes No DQA: Da						
	Re	esolution:	Disposit	ion:	(A: N/C C	losed:		Date:	· · · · · · · · · · · · · · · · · · ·			
NCR:			WORK OR	DER NON-COM	NFORMAN(CE (NCI	?)		*				
DATE	STEP	Description of NC	Corrective Action Section				Verific		Approval	Approval			
	J	Section A	Initial Chief Eng	Action Des	SCRIPTION Eng	Sign Date		on C	Chief Eng	QC Inspector			
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Work Orde Thursday, July 0						Page 3		
Item ID: Revision ID:	D3243-041			Accept		Set		1 18811(81 B(B(B (B) (B))BB)
Item Name: Start Date: Required Date: Reference:	7/7/2011 7/21/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item ID: Customer:		Stop	
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):	Date:	Rur 	Start Stop	
Sequence ID/ Work Center ID 170 HandFinish Hand Finishing		Operation Description Chemical Conversion Co Memo	at per QS1005 4.1	Set Up/ Run Hours 0.00	Tool ID Tool # Pla Co	•		Reject Insp. Number Stamp
180 		Small Fab Memo Install Inserts	s as per Dwg D3343	0.00		BI	108/	M 6

190

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00 Sulos/24



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W/O:			W	ORK ORDER CHANGE	ES						
DATE	STEP	PROCI	EDURE CHA	ANGE	Ву	C	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	·	PAR #:		NCR: Yes No DQA: Date:							
	R	esolution:	Disposition	on:	QA: N/C	Clos	ed:		Date: _		
NCR:		WC	ORK ORD	ER NON-CONFORMA	NCE (N	CR)		н			
DATE	STEP	Description of NC		n B		Verific	ation		Approval		
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	tion Sign & Date			on C	Chief Eng	QC Inspector	
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Work Orde				
Item ID:	D3243-	041		
Revision ID:				
Item Name:	Bracket .	Assemt	oly	
Start Date:	7/7/201	1	Start Qty: 6	5.00
Required Date:	7/21/20	11	Req'd Qty: 6	5.00



Page 4

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Setup Start



Stop

Cust Item ID: Customer:

Reference:

Approvals:	Process Plan:QC:	Date:	Tooling: _ SPC (Y/N):	Date:		R	un Sta Sto			
Sequence ID/	Operation		Set Up/	Tool ID Tool #	Plan	Accept	Reject	Reject	Insp.	
Work Center II	D Description		Run Hours		Code	Otv	Otv	Number	Stamp	

200

0.00

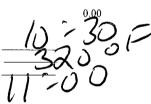
Powdercoat

Powder Coating

*****Mask Holes***** START TIME: OVEN TEMPERATURE:

Identify as per dwg & Stock Location: 327

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3



Accept

6 BR W8-25

210 QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

220

Packaging

Packaging

Memo

0.00

0.00

W/O:				WORK ORDER CHANGES									
DATE	STEP	-	PROCEDURE CHANGE					e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			-										
	-												
			PAR #:	_ Fault Categ	jory:	NCR: Ye	s No	DQA:	_ Date: _	<u> </u>			
	Res		on:	Disposition	:	QA: N/C	Closed:	<u> </u>	Date: _				
NCR:		W	ORK ORDE	R NON-CONFORM	JANCE (NO	CR)							
DATE	STEP		Description of NC		ection B	Ve	erification	Approval	Approval				
	3		Section A	Initial Chief Eng	Action Description Chief Eng	n Sig Da		Section C	Chief Eng	QC Inspector			
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Picklist Print

Thursday, July 07, 2011 1:00:37 PM

Work Order ID: 71716

Parent Item:

D3243-041

Parent Item Name:

Bracket Assembly



Start Date: 7/7/2011

Required Date: 7/21/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue

05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	212.9456	0.5499	3.473053 rB(1-	-8-3		
					116308 117285	<u>Loc</u> 212.945 28.475	5684	Loc Code	<u>-</u>	78दा			
FE-032-EF		Purchased	No	Location		180 Loc	Each	294.0000 Loc Code	4	²⁴ ///	68 J.	y Y	

Location Loc Qty ST285 294 110836 38 117168 156 117226 100

W/O:			WORK ORDER CHANGES													
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
				Name da												
			PAR #: Fault Category:													
	Res	olution:	Disposit	ion:	Q <i>A</i>	: N/C CI	osed:		Date: _							
NCR:	ļ	V	VORK OR	DER NON-CONF	ORMANC	E (NCR	R)									
DATE	STEP	Description of NC	Corrective Action Se				Verific	ation	Approval	Approval						
DATE	SIEP	Section A	Initial Chief Eng	Action Descr Chief Eng	iption 	Sign & Date	Section C		Chief Eng	QC Inspector						
								`								
	1		1	1		1	1		i	1						

DART AEROSPACE LTD	Work Order:	71716
Description: Bracket	Part Number:	D3243-1
Inspection Dwg: D3243 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.920	+/-0.010	11.926	+		PROWJ02	
11.420	+/-0.010	11.424	7		P	
Ø0.201	+0.005/-0.000	- 703	7		VBOZ	
Ø0.290	+0.005/-0.000	. 291	8		V	
1.375	+/-0.005	1.376	7		V	
5.273	+/-0.010	5.774	7		V	
0.500	+/-0.010	- 500	*		V	
0.500	+/-0.010	, 500	}		U	
0.750	+/-0.010	22	Z		V	
R0.50	+/-0.030	,50	7		R.G	
5.360	+/-0.010	5.363	>		V	
5.810	+/-0.010	5.811	7		V	
6.560	+/-0.010	6.564	4		V	
R0.250	+/-0.030	.756	ν		R.G	
						····
					-	

Measured by:	B	Audited by:	Audited by: Pro		N/A
Date:	11-8-3	Date:	W08/03	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.02.18	New Issue	(P/O D044-715-011)	KJ/JLM LA	
В	04.04.19	Removed dimension	KJ/RF		

